

Work Order ID 70792

Wednesday, June 15, 2011 10:56:42 AM



Page 1

Item ID: D2353

Accept



Setup Start



Revision ID:

Stop



Item Name: Stiffener

Start Date: 6/15/2011

Start Qty: 6.00



Cust Item ID:

Required Date: 6/22/2011

Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

P

Date: 11-16-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2353

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2353

☐ Dwg Rev: C

☐ Prog Rev: C

☐ 2-

Deburr if necessary

1311-6-23

(12)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

1311-6-23

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8/16/23

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

160



Powdercoat

Powder Coating

170



QC

Quality Control

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200

7:30

8:00

QC3- Inspect Part Finish

0.00

Memo

0.00

Identify as per dwg & Stock Location:

181

0.00

Memo

0.00

180



Packaging

Packaging

12x Ø M/L 11/06/28

12 Ø H 11/06/28

12x Ø M/L 11/06/28

W/O:		WORK ORDER CHANGES					
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Start Date: 6/15/2011

Start Qty: 6.00



Cust Item ID:

Required Date: 6/22/2011

Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/06/28 J

11-06-28

(12)

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Picklist Print

Wednesday, June 15, 2011 10:56:49 AM

Page 1

Work Order ID: 70792

Parent Item: D2353

Parent Item Name: Stiffener





Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A Removed from 9 Digit 05-11-10 EC
IPP: B 06.11.15 waterjet EC
IPP: c 06.12.07 ecn 836 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050  2024-T3 .050 sheet		Purchased	No			100	sf	122.3000	0.1463	0.924	2.		
													
117684													
117684													
117684													

117684

2

117684

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DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2353	REV. C SHEET 1 OF 1
DATE 06.11.13	TITLE STIFFENER		SCALE 1:2
REV	DATE	DESCRIPTION	
B	95.02.23	ADD TEXT	
C	06.11.13	ADD FLAT PATTERN; ADD NOTES; UPDATE DWG	

R0.354
(4 PLACES)

15.198
14.844

BEND
DOWN
90° x R0.13

Ø0.128
(TYP)

GRAIN
DIRECTION

**D2353F
FLAT
PATTERN**

1.382
0.691
0.352
0

13.878

12.912

11.946

10.980

10.014

9.048

8.082

7.116

6.150

5.184

4.218

3.252

2.286

1.320

0.354

0

0.40
(REF)



NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET, 0.050 THICK
PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T4S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7)
PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D2353" USING A WHITE
FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS
OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

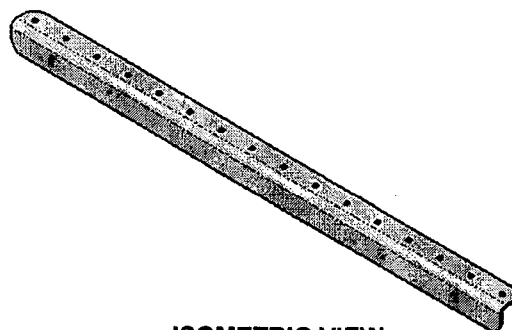
WITHOUT NOTICE

WORK ORDER

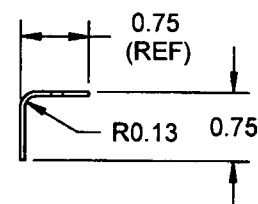
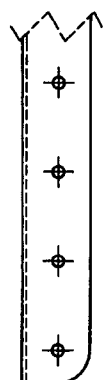
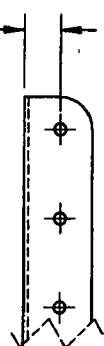
NO. 70792

RELEASED

06.11.28 [Signature]



ISOMETRIC VIEW
SCALE 1:4



**D2353
BEND DETAIL**

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